A basic cored wire for submerged arc welding.

Specifications	
Classifications	SFA/AWS A5.17 : F7A4-EC1 (OK Flux 10.71) SFA/AWS A5.17 : F7A5-EC1 (OK Flux 10.62) EN ISO 14171-A : S 42 4 AB T3 (OK Flux 10.71)
Approvals	ABS : 3YM BV : A3YM CE : EN 13479 (10.71) CE : EN 13479 DB : 52.039.14 DNV-GL : III YM LR : 3YM PRS : 3YM UKCA : EN 13479 VdTÜV : 09144

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+, AC
Diffusible Hydrogen	<5ml/100g
Alloy Type	C Mn

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
OK Flux 10.71			
As Welded	463 MPa	556 MPa	29 %
OK Flux 10.62			
As Welded	465 MPa	540 MPa	26 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
OK Flux 10.71		
As Welded	-40 °C	114 J
OK Flux 10.62		
As Welded	-60 °C	75 J
As Welded	-40 °C	140 J

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**S**	**P**
OK Flux 10.71				
0.07	1.61	0.59	0.010	0.015
OK Flux 10.62				
0.06	1.40	0.35	0.010	0.015

Deposition Data				
Diameter	**Amps**	**Volts**	**Wire Feed Speed**	**Deposition Rate**
2.4 mm	250-350 A	28-38 V	1.5-2.5 m/min	3.5-9.5 kg/h
3.0 mm	400-800 A	28-40 V	2.5-6.0 m/min	6.0-14.5 kg/h
4.0 mm	500-900 A	28-40 V	2.0-5.5 m/min	7.0-18.0 kg/h